

Work Order ID 77314

77314

Page 1

December-02-11 10:00:17 AM

Item ID: D2995 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw, 500
 Start Date: 02/12/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 16/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/02 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2995	Rev A1

110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D2995								

B12-1-12

(4)

120	HAAS CNC VERTICAL MACHINING #1	0.00							
120									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Inspect material for defects or damage prior to machining Machine as per folio FA119Deburr								

B.A 12/02/25

4 0

130	QC2- Inspect parts off machine FAI/FAIB	0.00							
130									
QC	Memo	0.00							
Quality Control									

B.A 12/02/25

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00				4			
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

(1X) SP12-02-27.

12/2/27

12-02-27
(4)

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Picklist Print

December-02-11 10:00:22 AM

Page 1

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Parent Item: D2995

D2995

Parent Item Name: Bearpaw, 500

Start Date: 02/12/2011

Required Date: 16/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A01.03.07New IssueEC
IPP Rev:B New Manufacturing Process 08-11-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10		Purchased	No			110	sf	451.7000	3.4	14.31579			
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MUHMWB10

UHMW 1" Black

**

B12-1-12

Location

Loc Qty

Loc Code

MAT018

451.7

117321

74.6

117738

96.3

117819

83.3

118814

1.5

119145

196

120035

(4)

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DART AEROSPACE LTD		Work Order:	177314
Description: Bearpaw		Part Number:	D2995
Inspection Dwg: D2995 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	0.619	✓		Vern	GA-01
0.250	+/-0.010	0.247	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
0.25 x 45°	+/-0.030 x 0.5°	0.252 x 45°	✓		Vern	GA-01
5.86	+/-0.030	5.864	✓		"	"
0.950	+/-0.010	0.943	✓		"	"
0.433	+/-0.010	0.430	✓		"	"
19.00	+/-0.030	19.00	✓		Tape	GA-12
4.25	+/-0.030	4.250	✓		Vern	GA-01
3.63	+/-0.030	3.625	✓		"	"
7.375	+/-0.010	7.375	✓		Vern	CNC-02
11.625	+/-0.010	11.625	✓		"	"
0.38	+/-0.030	0.377	✓		Vern	GA-01
3.081	+/-0.010	3.078	✓		"	"
17.73	+/-0.030	17.73	✓		Tape	GA-12
19.34	+/-0.030	19.34	✓		"	"
Ø0.260	+0.006/-0.001	Ø0.260	✓		Vern	GA-01
0.30	+0.030/-0.000	0.304	✓		D-6	GA-08
Ø0.93	+/-0.030	Ø0.930	✓		Vern	GA-01

Measured by:	JA	Audited by:	OML	Prototype Approval:	N/A
Date:	12/02/25	Date:	12/02/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	
B	09.05.19	Tolerances revised	KJ	

Dart Aerospace Ltd

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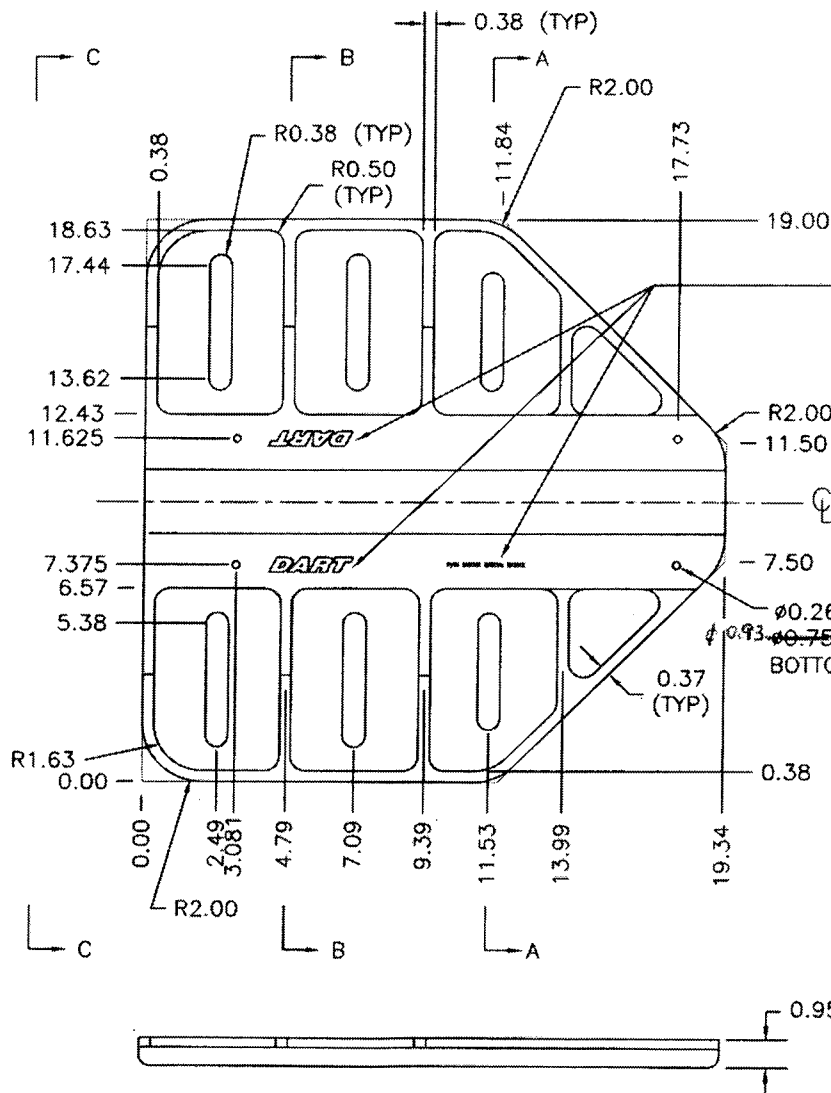


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	
DATE		TITLE	SHEET 1 OF 2	
01.02.23		BEARPAW	SCALE	
A	01.02.23	NEW ISSUE	1:6	
A1	03.01.06	0.93 was 0.75		

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER NO. 37314
M.C.J.
11/12/02

RELEASED
01.03.14



BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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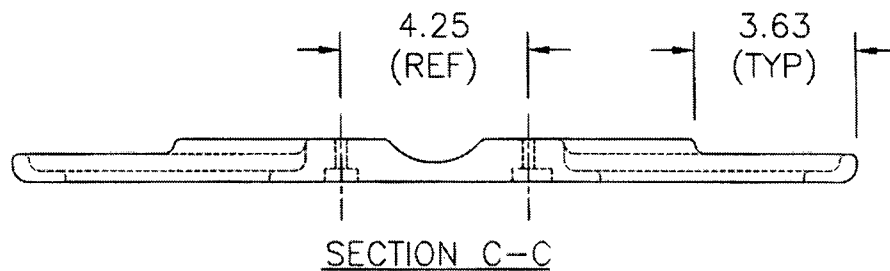
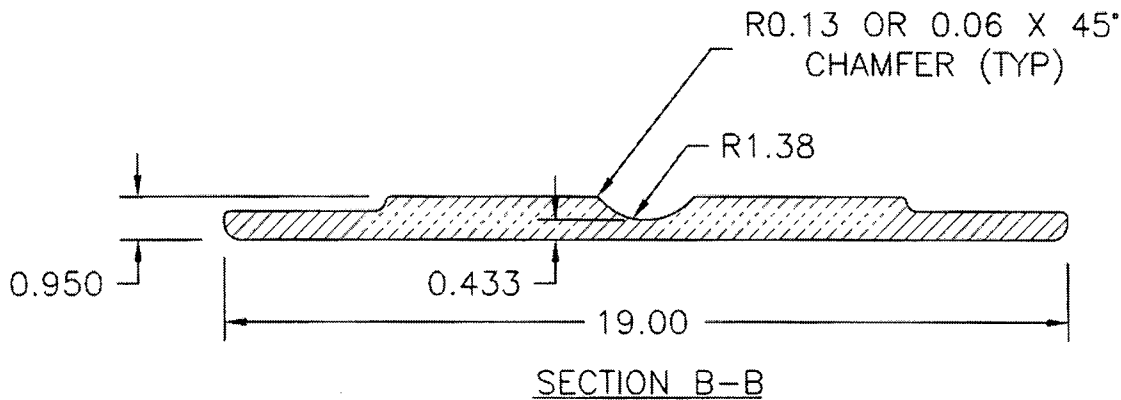
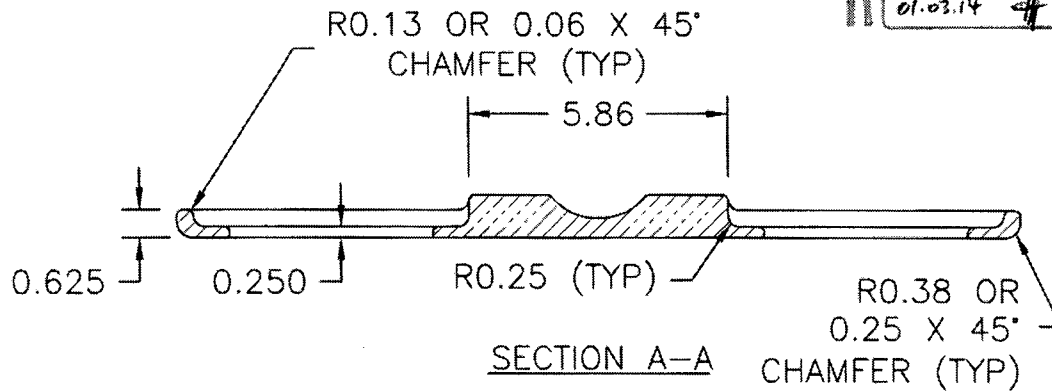
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2995	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED
01.03.14 *A*



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27314

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